

# Work Order ID 70238

Wednesday, June 01, 2011 2:24:54 PM



Page 1

Item ID:	D3609-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Doubler				Stop	
Start Date:	6/1/2011	Start Qty:	1.00			
Required Date:	6/2/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-06-01</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3609	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3609								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	<b>Memo</b>	0.00							
Quality Control									

B 11-6-1

1B 11-6-1

E 11-06-01

①

①

**Work Order ID 70238**

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Item ID: D3609-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

121



Brake NC

Brake NC

Form as per dwg

0.00

Memo

USE DT9760 TOOL

0.00

SB 11/06/01

①

122



Small Fab

Small Fab

Memo

1- TRIM AS PER DWG USING GUIDE LINES

0.00

SB 11/06/01

①

123



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

E 11.06.01

①

**Work Order ID 70238**

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Page 3

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

EE

11.06.01

①

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

USE DT9760 TOOL

11/6/12 DJ

Eagle

Eng 2106 Sure

MF 11-06-02

# Picklist Print

Wednesday, June 01, 2011 2:24:50 PM

Page 1

Work Order ID: 70238



Parent Item: D3609-1



Parent Item Name: Doubler

Start Date: 6/1/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-03-26 JLM  
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C  
AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA		Purchased	No			100	sf	72.5000	1.1769	1.238842			
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304/316 .032 Sheet



B11-6-1

Location

Loc Qty

Loc Code

020

7

109057

7

MAT020

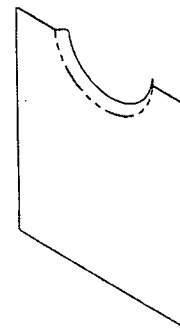
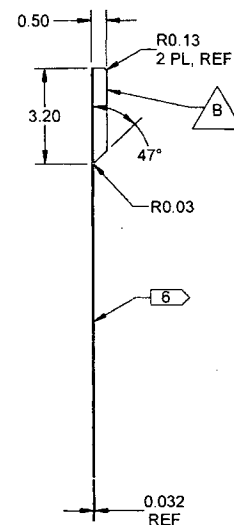
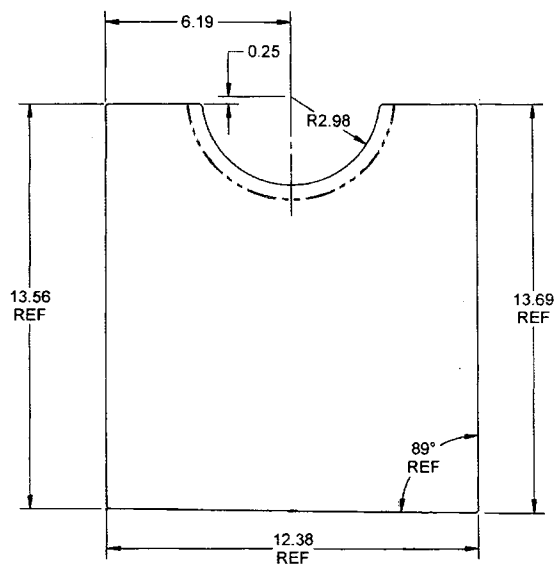
65.5

117379

65.5

117379

①



# **D3609-1 DOUBLER**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.44 lbs

**RELEASED**  
2011-05-03

PER ECN 11-552

# 70238

B	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.04.28
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.28		
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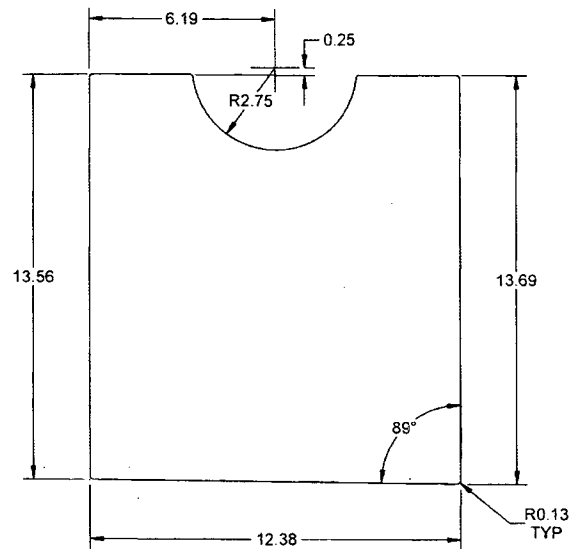
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3609-1F FLAT PATTERN**



**NOTES:**

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE  
 PER MIL-S-5059  
 OR AMS 5513 (304)  
 OR AMS 5524 (316)  
 OR ASTM 240  
 OR ASME SA240  
 PER DART SPEC M304S22GA

2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 1.44 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3609</b> REV. B
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE <b>DOUBLER</b> SCALE
DE APPR.		NTS
DATE	11.04.28	COPYRIGHT © 2007 BY DART AEROSPACE LTD
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**RELEASED**  
 2011-05-03  
 4P

#70238

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD	Work Order: 70738
Description: Double	Part Number: D3609-1
Inspection Dwg: D3609-1, Rev: 8	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

Measured by:	B
Date:	11-6-1

Audited by:	<i>RE</i>
Date:	11.06.01

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	